

Work Order ID 72546

Thursday, July 28, 2011 2:54:07 PM



Page 1

Item ID: D4018-3

Accept



Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 7/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/4/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-07-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4018

C

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4018
2- debur and remove identification markings

[Signature] 11.07.29 *(6)*

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

S wlos/02

(76)

120

Identify as per dwg & Stock Location: *WAG*

0.00



Packaging

Memo

0.00

Packaging

[Signature] 11.07.29 *(6)*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 72546

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Page 2

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Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 7/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/4/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/02

11-08-2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Thursday, July 28, 2011 2:54:23 PM

Page 1

Work Order ID: 72546



Parent Item: D4018-3



Parent Item Name: Rib


Start Date: 7/28/2011

Required Date: 8/4/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB
DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18
verified by:EC IPP Rev:E 11.01.31 chg qc5 to 6 DD verified by:ec

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TS0.500W.049  Square Tubing | | Purchased | No | | | 100 | f | 1,162.132 | 4.6042 | 29.07916 | | 11.07.29 | |

Location

Loc Qty

Loc Code

MAT034

1162.1324

116610

0.8383

117721

0.3234

117999

576.9707

118460

584

29.079

| W/O: | | WORK ORDER CHANGES | | | | | |
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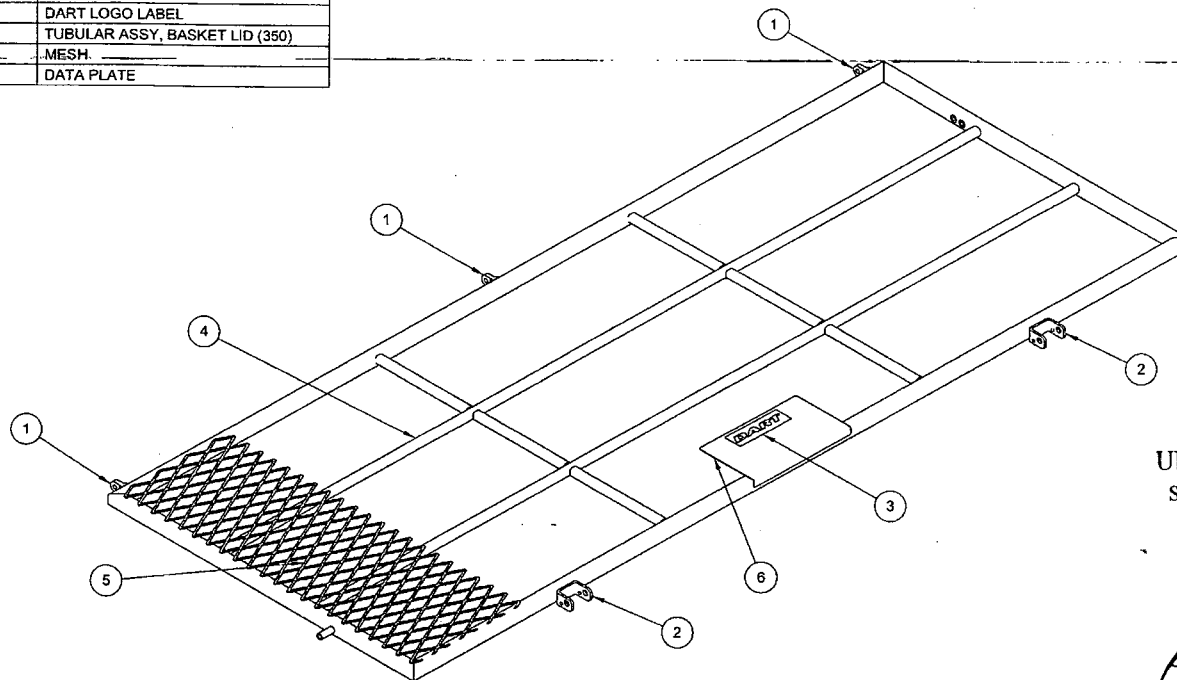
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|--------------------------------|
| | X | D4018-041 | SHORT BASKET LID ASSY (350) |
| 1 | 3 | D4016-3 | HINGE HALF, LID |
| 2 | 2 | D2581 | MOUNTING BRACKET |
| 3 | 1 | D2728-3 | DART LOGO LABEL |
| 4 | 1 | D4018-101 | TUBULAR ASSY, BASKET LID (350) |
| 5 | 1 | D4020-7 | MESH |
| 6 | 1 | D4021-3 | DATA PLATE |



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72546

11107-20

RELEASED
10.08.12
ECN 10-946

| | | | |
|------------|---|--|----------|
| C | REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A. | MB | 10.08.05 |
| B | BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED. WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)(C82). SIDE VIEWS ADDED (C1-4)(D1-4). | JPH | 10.03.25 |
| A | NEW ISSUE | JPH | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>ALS</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4018 REV. C TITLE SHORT BASKET LID ASSY (350) NTS SCALE SHEET 1 OF 4 | |
| DRAWN | <i>SC</i> | | |
| CHECKED | <i>SC</i> | | |
| MFG. APPR. | <i>AS</i> | | |
| APPROVED | <i>AS</i> | | |
| DE APPR. | <i>AS</i> | | |
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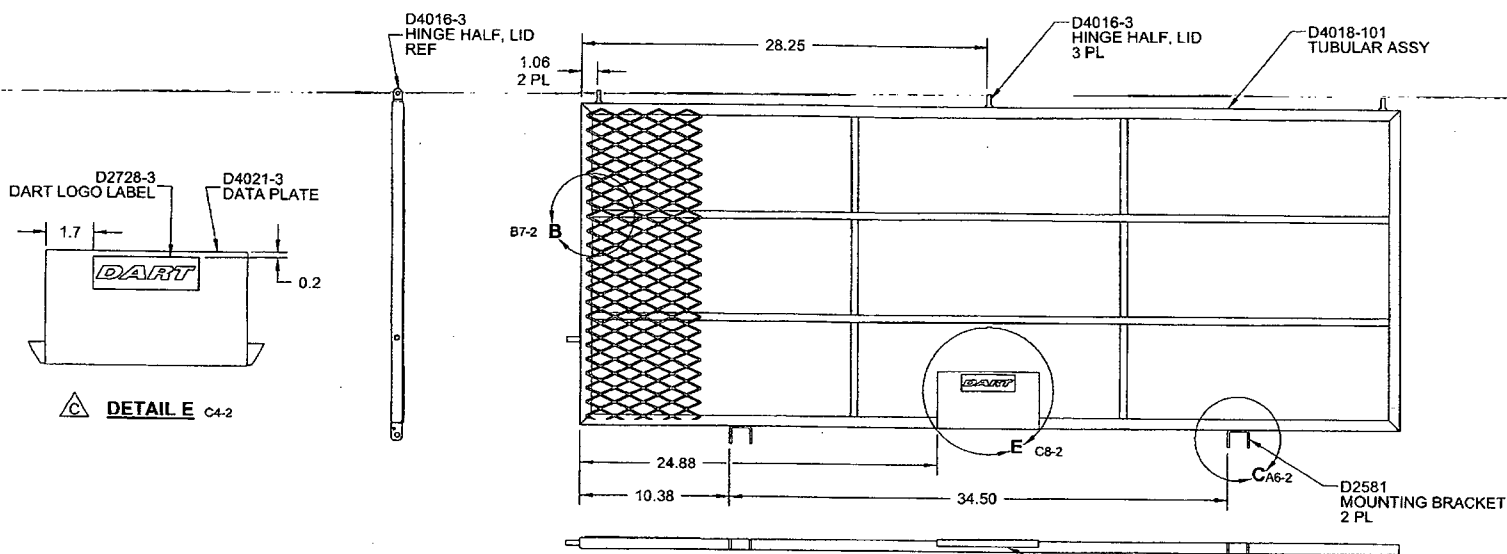
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

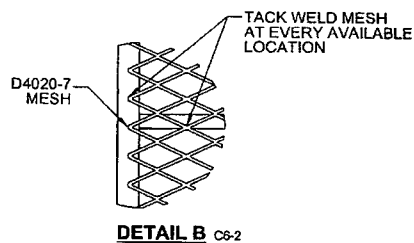
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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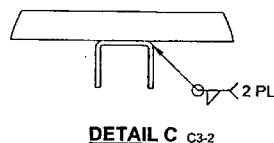
NOTE: Date & initial all entries



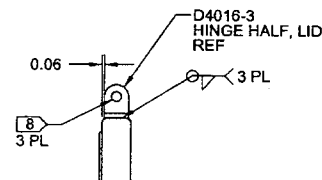
DETAIL E C4-2



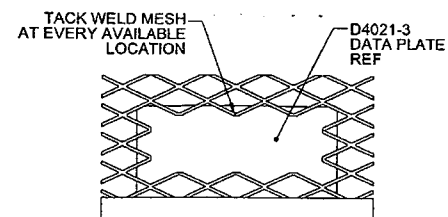
DETAIL B C6-2



DETAIL C C3-2



DETAIL D D1-2



VIEW A-A C1-2

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.5 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

| | | | |
|--|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | h | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | SC | DRAWING NO. | REV. C |
| MFG. APPR. | W | D4018 | SHEET 2 OF 4 |
| APPROVED | W | TITLE | SCALE |
| DE APPR. | W | SHORT BASKET LID ASSY (350) NTS | |
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RELEASED
10.08.12

22544

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

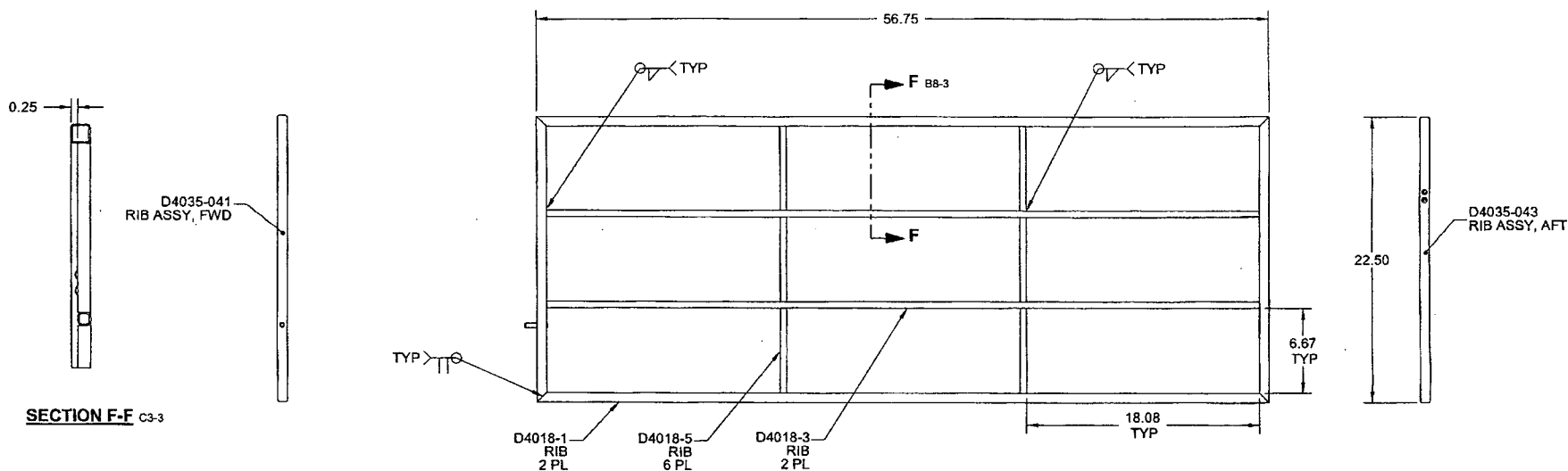
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

72846

| ITEM | QTY -101 | P/N | DESCRIPTION |
|------|-------------|-----------|--------------------------------|
| | X | D4018-101 | TUBULAR ASSY, BASKET LID (350) |
| 1 | 2 | D4018-1 | RIB |
| 2 | 2 | D4018-3 | RIB |
| 3 | 6 | D4018-5 | RIB |
| 4 | 1 | D4035-041 | BASKET LID RIB ASSY, FWD |
| 5 | 1 | D4035-043 | BASKET LID RIB ASSY, AFT |



8 > D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
10.08.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

| | | | |
|--|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | SC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | SC | DRAWING NO. | REV. C |
| MFG. APPR. | SC | D4018 | SHEET 3 OF 4 |
| APPROVED | SC | TITLE | SCALE |
| DE APPR. | SC | SHORT BASKET LID ASSY (350) NTS | |
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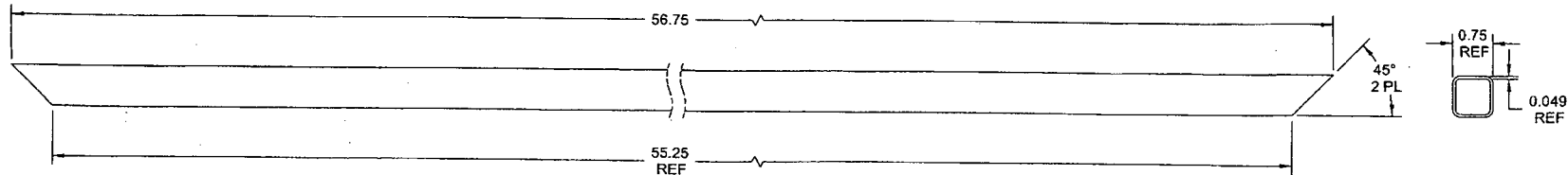
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

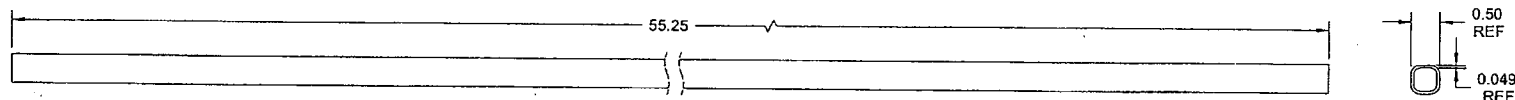
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NOTE: Date & initial all entries

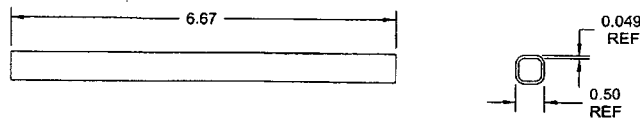
72546



D4018-1 RIB



D4018-3 RIB



D4018-5 RIB

RELEASED
10.08.12

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

| | | | |
|------------|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | A | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ISC | DRAWING NO. | REV. C |
| MFG. APPR. | AND | D4018 | SHEET 4 OF 4 |
| APPROVED | AND | TITLE | SCALE |
| DE APPR. | AND | SHORT BASKET LID ASSY (350) | NTS |
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